

Work Order ID 57251

March 31, 2010 10:03:55 AM



Page 1

Item ID: D5951

Accept

Revision ID:

Item Name: Saddle, 205

Start Date: 31/03/2010 Start Qty: 4.00

Required Date: 09/04/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-3-31

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5951

Rev B

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

1-Machine as per folio D5951, Ensure Batch Number is entered ☐ 2-Machine
Keyway ☐ 3-Deburr & Tumble

110



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

0.00

Memo

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

10.4.8

10.4.8

SP 10/04/08

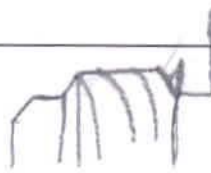
(4)

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
								

NOTE: Date & initial all entries

Work Order ID 57251

March 31, 2010 10:03:55 AM



Page 2

Item ID: D5951

Accept



Setup Start



Revision ID:

Item Name: Saddle, 205

Stop



Start Date: 31/03/2010 Start Qty: 4.00



Required Date: 09/04/2010 Req'd Qty: 4.00

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

9:15AM

OVEN TEMPERATURE:

FINISH TIME:

320°F

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 10-4-9

(4) 4

7 JV 10/04/09

(4) 4

BR 10-4-9

(4) 4

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Work Order ID 57251

March 31, 2010 10:03:55 AM



Page 3

Item ID: D5951

Revision ID:

Item Name: Saddle, 205

Start Date: 31/03/2010 Start Qty: 4.00

Required Date: 09/04/2010 Req'd Qty: 4.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location: 430

Memo

0.00

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

PC 14/03 (4)

10/04/15 JF
PS 10-4-14
(4)

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NOTE: Date & initial all entries

Picklist Print

March 31, 2010 10:03:58 AM

Page 1

Work Order ID: 57251

Parent Item: D5951

Parent Item Name: Saddle, 205


Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:E Re-Format 05-11-29 JLM

Start Date: 31/03/2010

Required Date: 09/04/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-013		Manufactured	No			100	Each	28.0000	4.0000			
												
Saddle Billet												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT47	28	
46413	28	

Ref 10.4 - 8

x4

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DART AEROSPACE LTD		Work Order:	57251
Description: Outer Fwd Saddle		Part Number:	D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.437	0.444		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.248	5.248	5.248	5.248		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.320	.320	.320	.320		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.054	3.054	3.054	3.054		
J	4.575	4.585		4.578	4.578	4.578	4.578		
K	0.315	0.322		.320	.320	.320	.320		
L	0.495	0.505		.503	.501	.501	.501		
M	0.490	0.510		.505	.505	.505	.505		
N	1.615	1.635		1.635	1.635	1.635	1.635		
O	7.990	8.010		8.002	8.002	8.002	8.002		
P	2.240	2.260		2.260	2.260	2.260	2.260		
Q	0.307	0.312		.313	.313	.313	.313		
R	0.760	0.765		.761	.761	.761	.761		
S	0.490	0.510		.500	.500	.500	.500		
T	1.375	1.395		1.395	1.391	1.389	1.390		
U	2.000	2.020		2.020	2.010	2.010	2.010		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: *[Signature]*
Date: 10.4.8

Audited by: *[Signature]*
Date: 10/04/08

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	<i>[Signature]</i>

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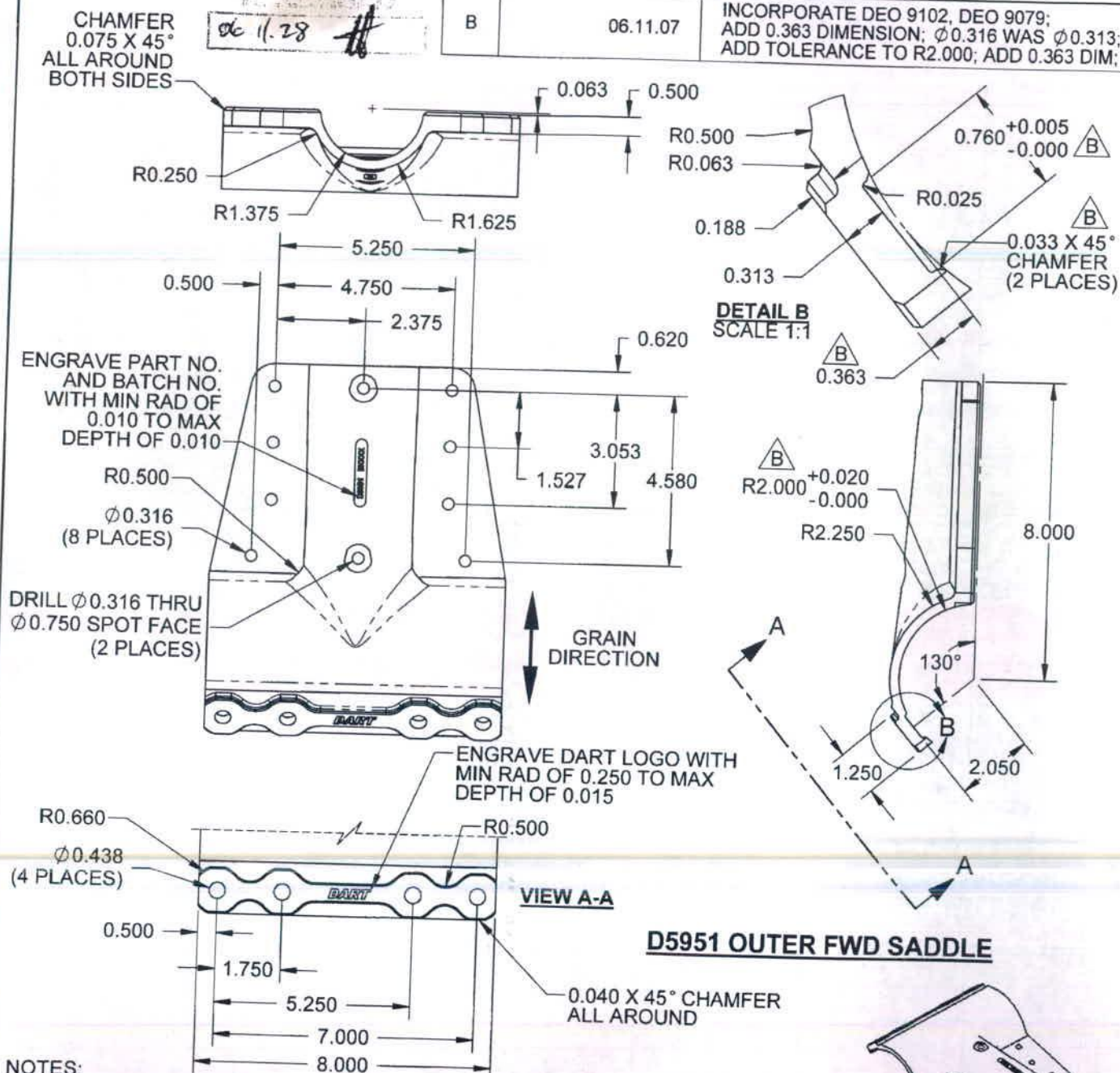
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO
WITH
WORK ORDER
NO. 57251

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED CE	APPROVED CB	DRAWING NO. D5951
DATE 06.11.07	TITLE OUTER FWD SADDLE	REV. B SHEET 1 OF 1
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

ISOMETRIC VIEW
SCALE 1:8

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